

Work Order ID 81176

March-12-12 8:38:29 AM

81176

Page 1

Item ID: D4017-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 09/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4017

C

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4017
2- Deburr and remove identify marks

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81176

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 09/03/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 19/03/2012 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/03/20

112-03-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-12-12 8:38:36 AM

Page 1

Work Order ID: 81176

81176

Parent Item: D4017-7

D4017-7

Parent Item Name: Rib

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB
DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18
verified by:EC IPP Rev:E 11.01.18 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased		No		100	f	443.0184	0.0675	0.142105			

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

PL 12 03 20

Location	Loc Qty	Loc Code
MAT018	418.2411429	
117775	93.6739	
118472	47.1990839	
118880	0.2736	
119147	76.4906	
<u>119643</u>	39.6981	
120494	160.905859	
MAT034	1.8507	
117337	1.8507	
WA035	22.92654	
118184	22.92654	

~~4.4~~ 1.0

W/O:		WORK ORDER CHANGES					
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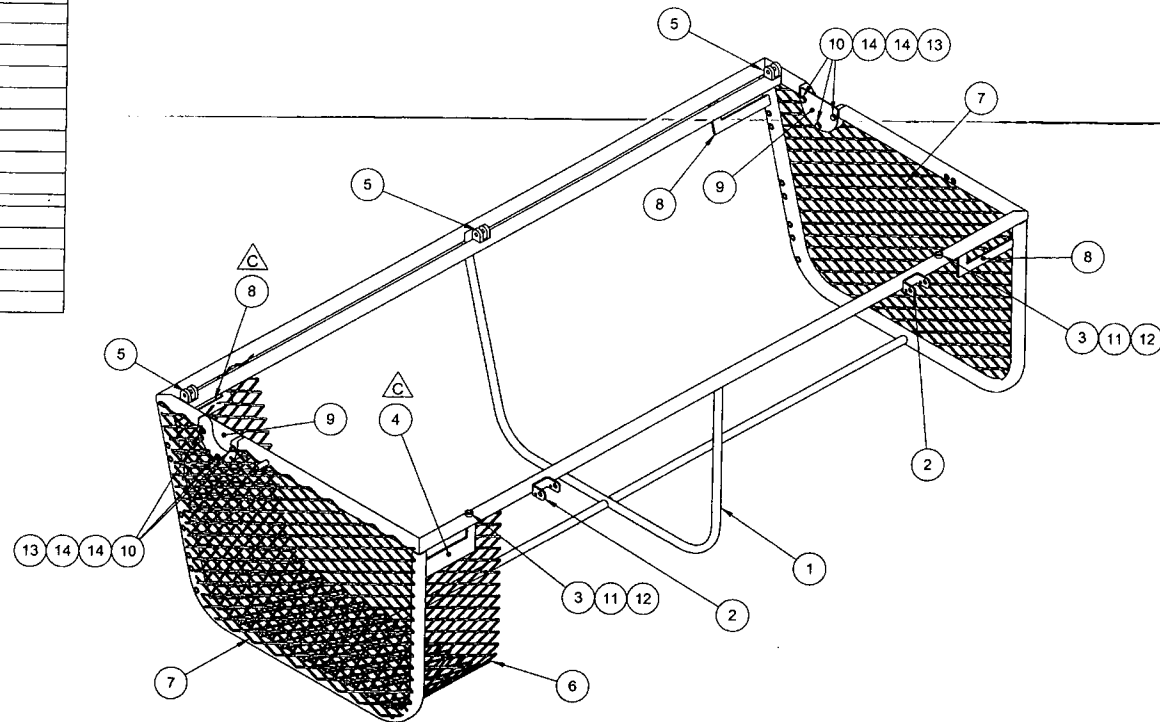
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81176 MLCJ
12/03/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

ECN 10-516
RELEASED
10.08.12 P

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C 10A; NAS1149F0332P WASHER WAS NAS1149C0332R, SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED, DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 1 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SHORT BASKET BASE ASSY (350)	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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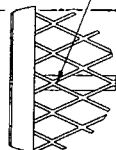
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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81176

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



DETAIL C D5-2

SECTION F-F
TYPICAL FOR ALL
HANDLE PLATES

D5-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4021-1
HANDLE PLATE

D4020-3
MESH

D6-2 F

C8-2 C

10.38

34.50

D4017-101
TUBULAR ASSY

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL (8)

D2581
MOUNTING BRACKET
2 PL

2 PL

D4020-11
END MESH

DETAIL D
A4-3

6 PL (9)

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

(9)

(9) 4 PL

TRIM MESH TO
CLEAR BUSHING
Ø 0.75

0.38
TYP

D3913-15
WIDE HANDLE PLATE

0.75
2 PL

A

27.94

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

B

3 PL

B6-3 A

B2-3 B

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12 9'

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JES	D4017	SHEET 2 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	SHORT.BASKET.BASE ASSY (350) - NTS.	
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W/O:		WORK ORDER CHANGES					
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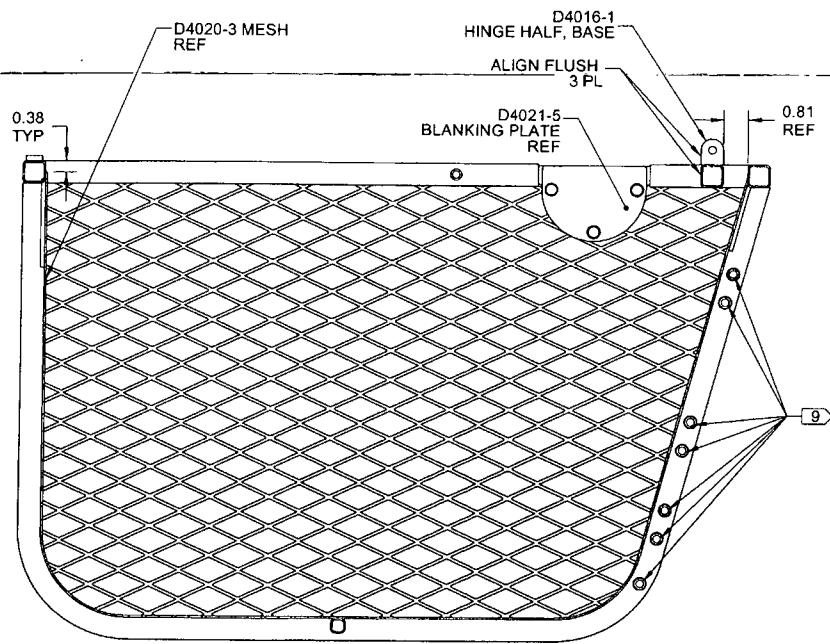
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

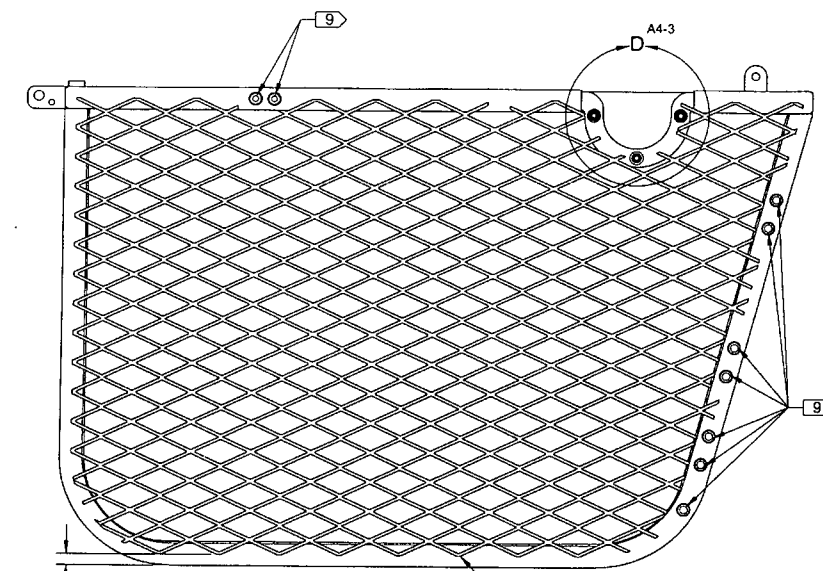
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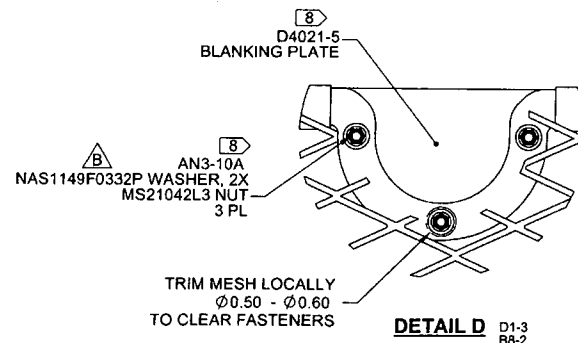
81176



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

RELEASED
10.09.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	TP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.F.S.	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 3 OF 5
APPROVED	J.F.S.	TITLE	SCALE
DE APPR.	J.F.S.	SHORT-BASKET-BASE ASSY (350) - NTS	
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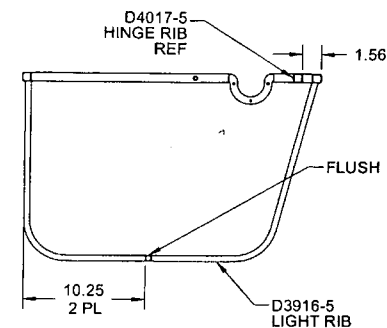
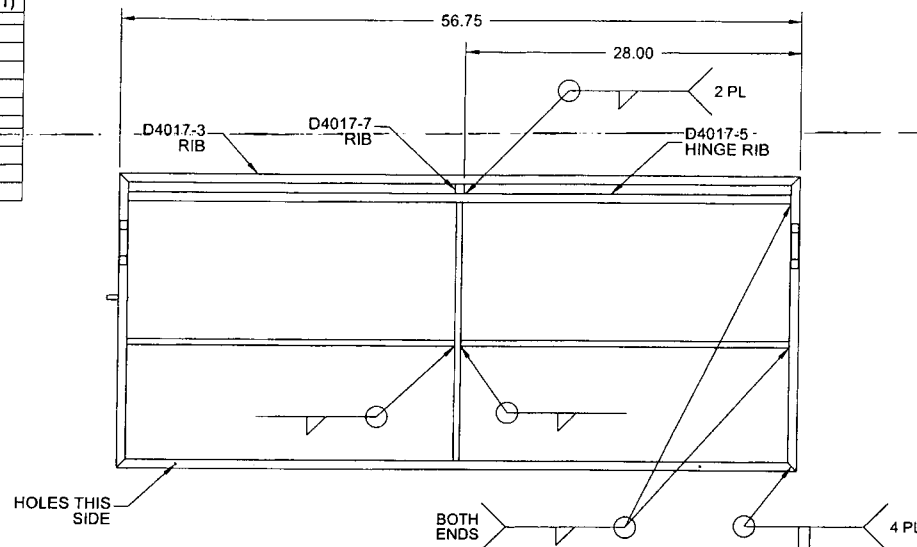
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

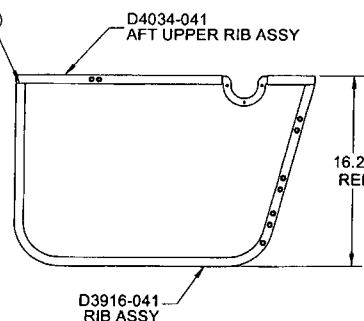
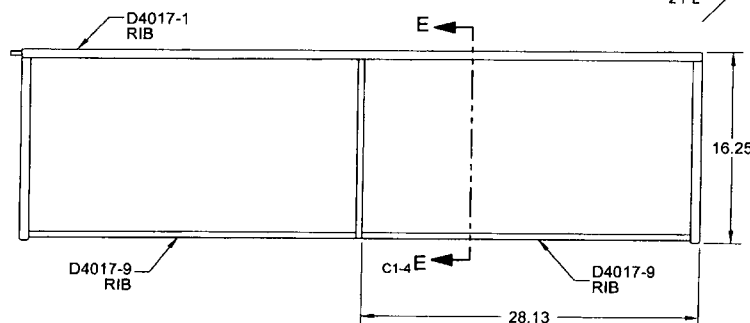
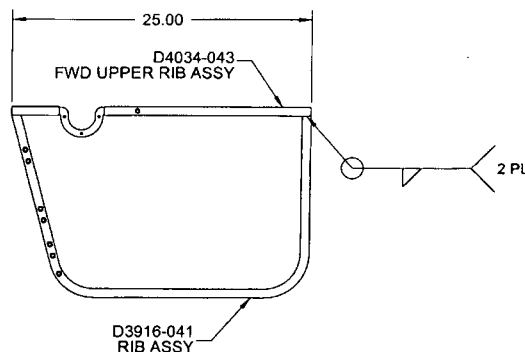
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	STS	D4017	SHEET 4 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	SHORT BASKET-BASE ASSY (350) NTS	
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10.06.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

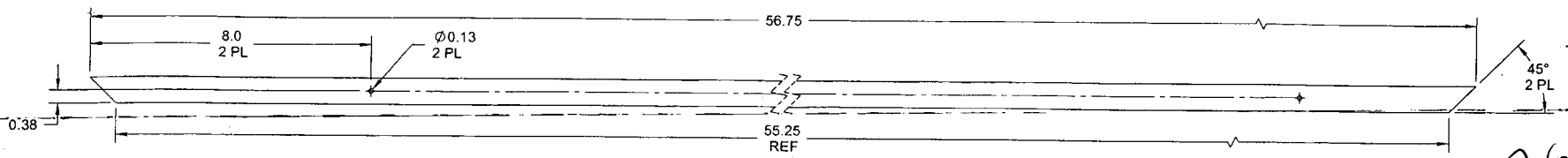
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

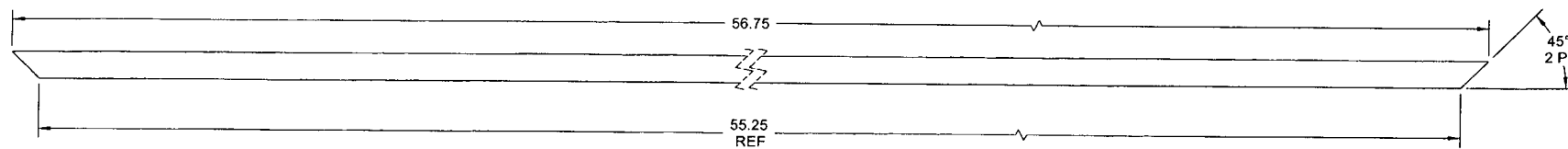
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D4017-1 RIB

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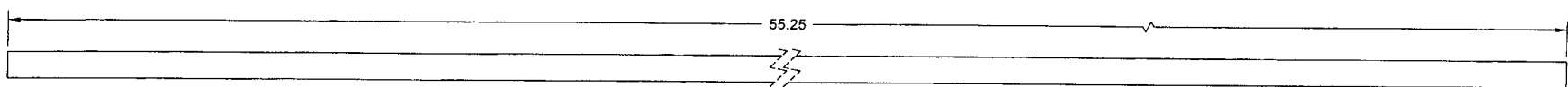
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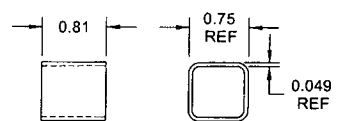
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B

B

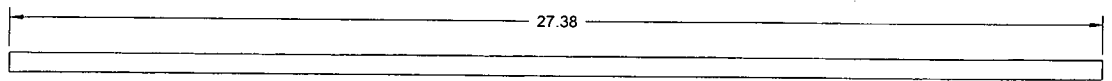


D4017-5 HINGE RIB



D4017-7 RIB

D4017-9 RIB



- NOTES:**
 1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
 REF DART SPEC. M304TS0.750W.049
 -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
 REF DART SPEC. M304TS0.500W.049
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
 10.08.12 40

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4017	REV. C
MFG. APPR.	JF.S. JELM.	SHEET 5 OF 5	
APPROVED	AM	SCALE	
DE APPR.	JP	SHORT BASKET BASE ASSY (350) NTS	
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8 7 6 5 4 3 2 1

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